

Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 40998

Estimate Number : 12568

P.O. Number :

This Issue : 06/08/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 06/08/2008 Type : LARGE FAB ASSY

Previous Run : 40269

Written By :

Checked & Approved By : JUL 08-8-06

Comment : Est. Rev:A New Issue 06-11-08 JLM  
est rev B ecn1019, added D2807-041 EC verified by:DD

Drawing Name : HELI-ACCESS STEP RH (FOLDING)

Part Number : D412630034

Drawing Number : IIN D412-630

Project Number : N/A

Drawing Revision : L

Material :

Due Date : 28/08/2008

Qty: 5 Um: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0

D2012107

Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

33585 x1

AS 08/11/13 (x1)

40274

AS 08/08/07 (x5)

3.0

D2803042

Bracket Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

34017 x1 AS 08/11/13

34017 x2

AS 08/08/07 (x5)

4.0

D2804042

Bracket Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

35827 x1 AS 08/11/13 (x1)

35827

AS 08/08/07 (x5)

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Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Prop

Batch:

35751

35751 x 2

AS 08/11/13 (X1)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

2

D2813

Washer

34020 x 2

AS 08/11/13 (X1)

7.0

D3562042

Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Step Weldment LH

Pick:

Qty

Part Number

Description

Batch

1

D3562-042

Step Weldment RH

~~B41039~~

B 41649

08/11/13

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

4

D3395-1

Bushing

41035 x 4

AS 08/11/13 (X1)

41035 x 6

33578 x 14

AS 08/08/07 (X5)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

2

AN3C21A

Bolt

M161189 x 2

AS 08/11/13 (X1)

M161092 x 1

M1610772 x 1

101189

AS 08/08/07 (X5)

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	AN8C16	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M105909 x2 AS 08/11/13 (x1)

106066 AS 08/08/07 (x5)

11.0	AN310C8	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M106431 x2 AS 08/11/13 (x1)

M106431 AS 08/08/07 (x5)

12.0	MS24665302	Cotter Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763 x2 AS 08/11/13 (x1)

M106763 AS 08/08/07 (x5)

13.0	NAS1515H3	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M107101 x6 AS 08/11/13 (x1)

M10761 AS 08/08/07 (x5)

14.0	NAS1515H5L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964 x4 AS x1

M106541 x5 AS 08/08/07 (x5)

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Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Washer

M106575 x 4 AS 08/11/13 (2)

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M106575

AS 08/08/07 (2)

16.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Nut

Batch

M108880 x 4 AS 08/11/13 (2)

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108672

AS 08/08/07 (2)

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Screw

M101390 x 2 AS 08/11/13 (+1)

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

AS 08/08/07 (2)

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M104251

AS 08/11/13 (2)

AS 08/09/11 (2)

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/11/13 (2)

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Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



B35630



54

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description  
2 D2806-1 Bushing

Batch

35630

JS 08/09/11

(XS)

22.0 D28063 Bushing



B36534



54

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description  
2 D2806-3 Bushing

Batch

B 36534 x2  
3619 x8 labalund

JS 08/09/11

(XS)

23.0 D28105 Strut



B346900



54

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number Description  
1 D2810-5 Strut

Batch

36521 x1  
341029 x4

JS 08/09/11

(XS)

24.0 D33961 Spacer



B34025



54

Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number Description  
2 D3396-1 Spacer

Batch

34025

JS 08/09/11

(XS)

25.0 AN4C6A Bolt



8/4/13 M107242



(1x)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description

Batch

M107242

JS 08/09/11

(XS)

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Seq. #:	Machine Or Operation:	Description :
1	AN4C6A Bolt	
26.0	AN4C10A Bolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
	Bolt	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	1 AN4C10A Bolt M101189	SS 08/09/11 (x5)
27.0	AN4C15A Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Bolt	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	2 AN4C15A Bolt M107082	SS 08/09/11 (x5)
28.0	AN44C7A Eyebolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
	Eyebolt	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	1 AN44-C7A Eyebolt M100446	SS 08/09/11 (x5)
29.0	AN5C15A Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Bolt	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	2 AN5C15A Bolt M105125	SS 08/09/11 (x5)
30.0	NAS1515H4 Washer	
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)	
	Washer	
	Pick: Packing Kit	
	Qty Part Number Description Batch	
	7 NAS1515H4 Washer M108558	SS 08/09/11 (x5)

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Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



M108334



SP

Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M108334

AS 08/09/11

(X5)

32.0

MS210434

Nut



M109105



SP

Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M108672

AS 08/09/11

(X5)

33.0

MS210435

Nut



M18535

8/4/13



SP

Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M108583

Fix this one in and pulled 9 for many.

(X5)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/11/14 (X1210)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

A

8/14/14

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME 08-11-14